

Date: Monday, 7/16/2007 2:44:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33554
 Estimate Number : 12841
 P.O. Number : N/A
 This Issue : 7/16/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 33553
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-04-24 JLM

Drawing Name : BALL STUD
 Part Number : D36221
 Drawing Number : D3622 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 7/23/2007 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303H0500	303 HEX BAR
		Comment: Qty.: 0.1134 f(s)/Unit Total : 2.2680 f(s) 303 HEX BAR .500" Batch: M102286
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-TURN AS PER FOLIO FA686 & DWG D3622 , FOLIO REV: <u>A</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST

Date:
User:

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL STUD

Job Number: 33554

Part Number: D36221

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



35

Comment: FINAL INSPECTION/W/O RELEASE

7/07/08

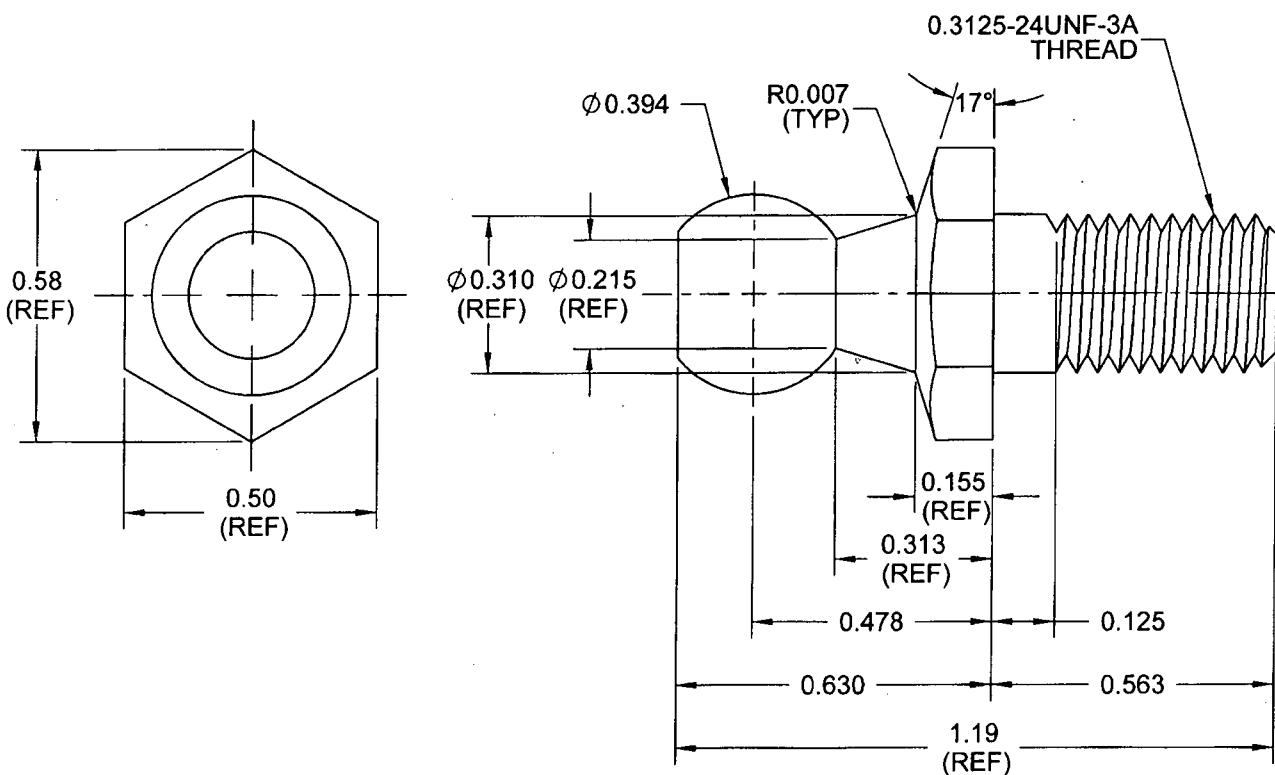
Job Completion



JH 07-08-07

DART

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>P/H</i>	APPROVED <i>H/H</i>	DRAWING NO. D3622	REV. A	SHEET 1 OF 1
DATE 07.04.13		TITLE BALL STUD	SCALE NTS	
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE		

RELEASED
07.07.11
PER ECU# 1001**D3622-1 BALL STUD**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33554

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	
Description: Crosstube Assembly	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.3125-.24	.3125/.-305	.310			
	PD	.285/.282	.285			
	.563	+/- .010	.563			
	.125	+/- .010	.125			
	.155	+/- .010	.150			
	.313	+/- .010	.310			
	.478	+/- .010	.478			
	.630	+/- .010	.631			
	1.19	+/- .030	1.193			
	.394 Ø	+/- .010	.3935			
	.310 Ø	+/- .010	.305			
	.215 Ø	+/- .010	.215			
	.58Ø	+/- .030	.580			
	.50	+/- .030	.498			
	R.007	+/- .010	.015			
	17°	+/- 12°	17°			
SIDE B						

Measured by:	<i>RP/8.5</i>	Audited by:	<i>SD</i>	Prototype Approval:	N/A
Date:	07/08/07	Date:	07.08.07	Date:	N/A
Rev	Date	Change	Revised by		
A		New Issue	<i>KJ/JLM</i>		